

# Work Order ID 130508

Friday, March 13, 2015 12:54:03 PM

\*130508\*

Page 1

Item ID: D3793-1 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Wearplate Fwd

Start Date: 3/13/2015 Start Qty: 16.00 \*16\*

Required Date: 3/13/2015 Req'd Qty: 16.00 \*16\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1503-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3793                          | Rev A                    |                      |         |        |              |               |               |                  |                |

100 0.00

\*100\*

Waterjet

FLOW CNC Waterjet

304.040

FLOW WATER JET

Memo

1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-  
Debur if necessary

24 0 Jm 15-3-15

110 0.00

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

24 0 Jm 15-3-15

120 0.00

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

(24) 15-3-16

DAS  
9  
9-89



# Work Order ID 130508

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**\*130508\***

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Item ID: D3793-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Fwd  
 Start Date: 3/13/2015 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 3/13/2015 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160 QC3- Inspect Part Finish 0.00

**\*160\***

QC

Memo

Quality Control

0.00

(24)

DAS

38

9-89

MAR 20 2015

170 Identify as per dwg & Stock Location: FP-002 0.00

**\*170\***

Packaging

Memo

Packaging

0.00

x24 d Jll 15/03/20

180 QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC

Memo

Quality Control

0.00

ML5 150320

MF

15-3-20

# Picklist Print

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Page 1

Work Order ID: 130508

**\*130508\***

Parent Item: D3793-1

**\*D3793-1\***

Parent Item Name: Wearplate Fwd

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S20GA

Purchased

No

100

sf

343.7123

0.5902

10

**\*M304S20GA\***

\*\*

16

Im 5-3-15

304/316 .040 Sheet

## Location

## Loc Qty

## Loc Code

MAT

212.6

m131700

212.6

MAT020

131.1123

m130345

1.5139

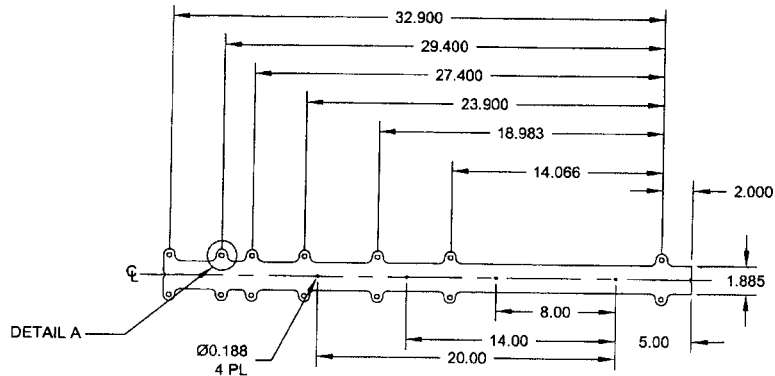
m131060

129.5984

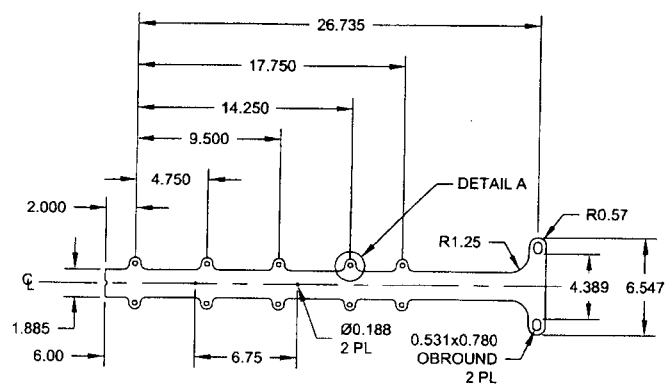
131700

131700

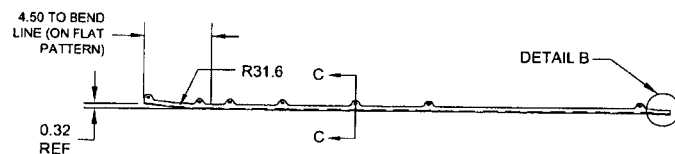




**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

SHOCCY  
RECEIVED

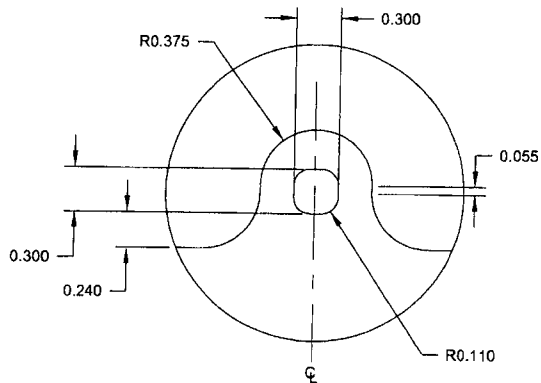
UNCLASSIFIED  
SUBJECT TO DECLASSIFICATION  
DATE 130508 MLC  
BY 1503-13

RELEASED  
08.05.14

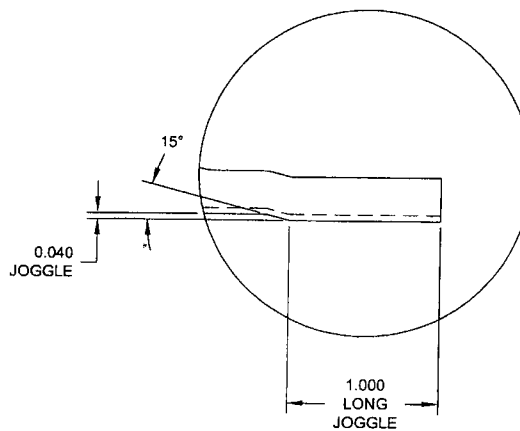
| REV.       | DESCRIPTION | PH                                                                                                                                                                                                                                                                                        | DATE         |
|------------|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE   | PH                                                                                                                                                                                                                                                                                        | 08.05.14     |
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| CHECKED    | PH          | DRAWING NO.                                                                                                                                                                                                                                                                               | REV. A       |
| MFG. APPR. | PH          | D3793                                                                                                                                                                                                                                                                                     | SHEET 1 OF 2 |
| APPROVED   | PH          | TITLE                                                                                                                                                                                                                                                                                     | SCALE        |
| DE APPR.   | PH          | WEARSHOE                                                                                                                                                                                                                                                                                  | NTS          |
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8 7 6 5 4 3 2 1

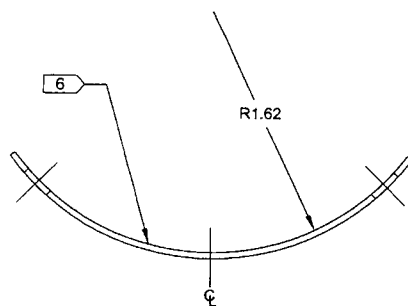
D



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-23/102

|            |          |                                                                                                                                                                                                                                                                                                    |              |
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| MFG. APPR. | IS       | D3793                                                                                                                                                                                                                                                                                              | SHEET 2 OF 2 |
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8 7 6 5 4 3 2 1

B

A